

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : _____			

Work Order ID 158605

Tuesday, March 28, 2017 10:20:00 AM

158605

Page 2

Item ID: D120-638-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: EC120 Bearpaws
Start Date: 3/28/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 4/7/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00							
180									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD120-638-011 LOCATION: FG014								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.20							
Quality Control									

DAS 27 9-89
MAR 27 2017
DAS 21 9-89
MAR 30 2017
DAS 21 9-89
MAR 30 2017

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, March 28, 2017 10:20:03 AM

Page 1

Work Order ID: 158605

158605

Parent Item: D120-638-011

D120-638-011

Parent Item Name: EC120 Bearpaws

Start Date: 3/28/2017

Required Date: 4/7/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B Added Step 2 08-04-16 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2435 *D2435* Bearpaw		Manufactured	No			160	Each	5.0000	2	4			
									**				
					<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>					
					ST446A	5							
					150969	1							
					155930	4				4			
D2182B050 *D2182B050* Clamp Cushion Black 5.0 " Long		Manufactured	No			160	Each	29.0000	4	8			
									**				
					<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>					
					ST639	29							
					152511	29				8			
D2274 *D2274* Radius Block		Manufactured	No			160	Each	755.0000	8	16			
									**				
					<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>					
					FG	12							
					86855	12							
					ST006	79							
					152449	79				10			
					ST012a	664							
					155086	504							
					157272	160							

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				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause			FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				
Misidentified ☐	Past Due ☐					

Picklist Print

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Page 2

Work Order ID: 158605

158605

Parent Item: D120-638-011

D120-638-011

Parent Item Name: EC120 Bearpaws

Start Date: 3/28/2017

Required Date: 4/7/2017

Start Qty: 2.00

Required Qty: 2.00

D2438

Manufactured No

160

Each

90.0000

4

8

D2438

Clamp

**

DAS
6
9-89

MAR 29 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST542

90

151376

10

152451

24

155069

44

155929

12

8

DAS
27
9-89

D2529

Manufactured No

160

Each

484.0000

8

16

D2529

Washer

**

DAS
6
9-89

MAR 29 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST008

484

155073

384

157443

100

10

DAS
27
9-89

AN4-15A

Purchased No

160

Each

177.0000

8

16

AN4-15A

Bolt

**

DAS
6
9-89

MAR 29 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

10

120449

10

ST343

167

m135859

167

16

DAS
27
9-89

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Shop Packet Print

Page 2

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								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Work Order ID: 158605

158605

Parent Item: D120-638-011

D120-638-011

Parent Item Name: EC120 Bearpaws

Start Date: 3/28/2017

Required Date: 4/7/2017

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

160

Each

1,923.000

8

16

NAS1149D0463.J

Washer

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

67

M134508

13

M135056

54

ST263

1856

M136838

856

M136983

1000

DAS
6
9-89 MAR 29 2017 DAS
28
9-89

MS21042L4

Purchased

No

160

Each

1,261.000

8

16

MS21042L 4

Nut

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

10

m133363

10

GA

172

m135058

172

OVER007

500

m136986

500

ST303

579

m136450

500

m136838

79

DAS
6
9-89 MAR 29 2017 DAS
28
9-89

DQA: _____ Date: _____



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Misidentified ☐	Past Due ☐																																																																

DART



RELEASED
98.06.17 KE

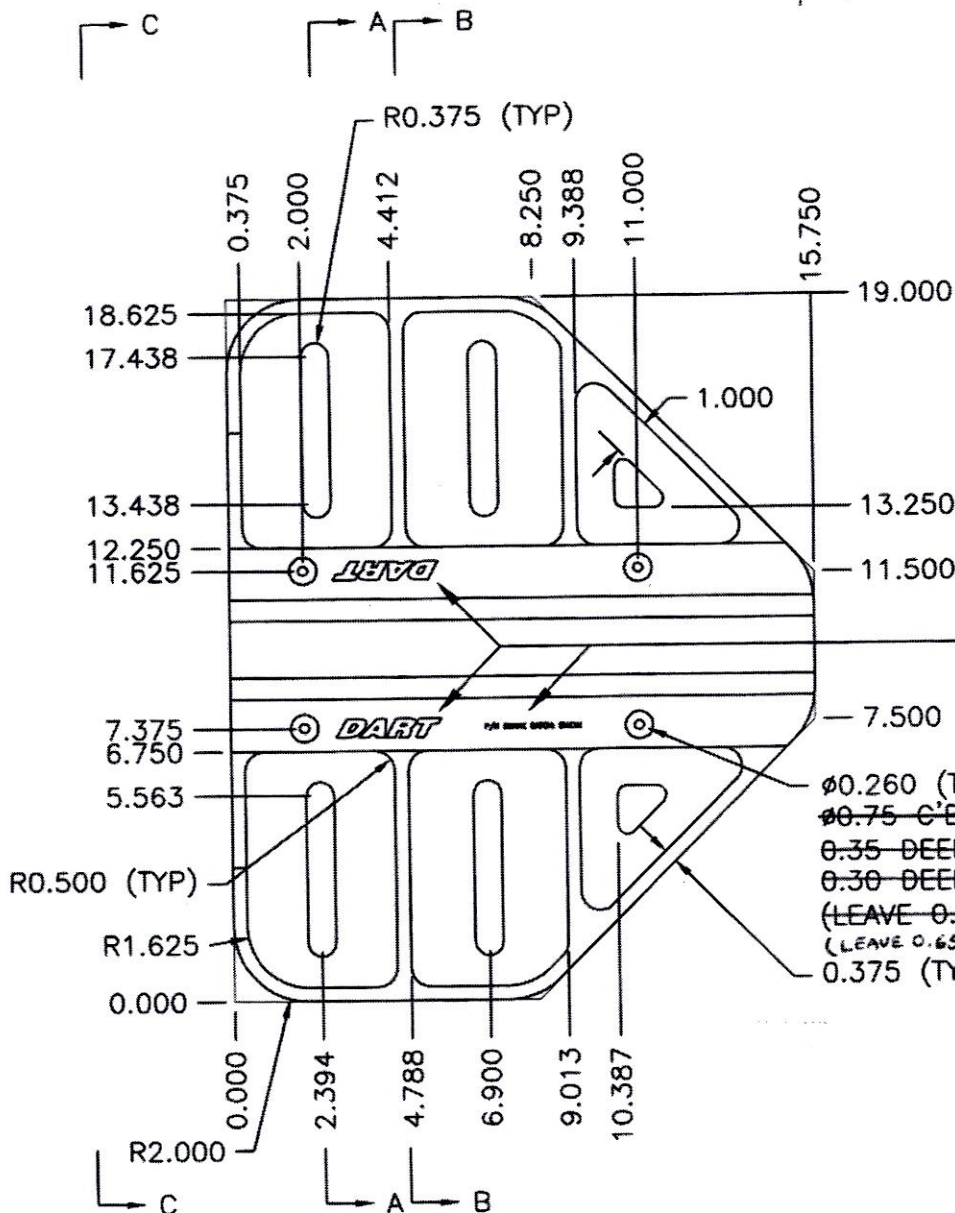
E1 02.12.17 Ø0.93 WAS Ø0.75 ~~RE~~

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158605
MCS

9143

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2435	SHEET 1 OF 2
DATE 98.05.19	TITLE BEARPAW	SCALE 1:5	
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: Date:

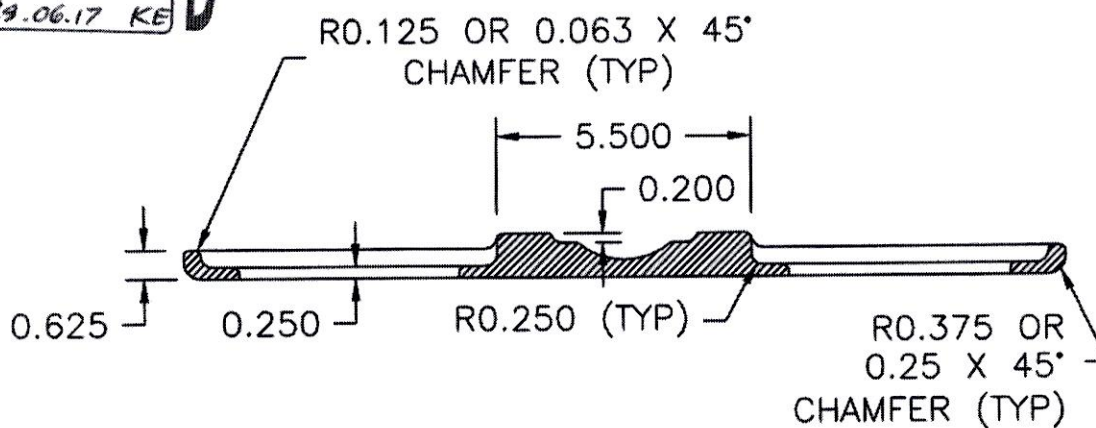
Work Order update only

Work Order: _____										
Part No. _____										
NCR No. _____										
DISPOSITION										
Rework		Skid-tube		Cross tube		Water Jet		Engineering		
Scrap		Machining		Small Fab		Prod. Eng. Coord.		Quality		
Use-as-is		Thermoforming		Finishing		Rec/Store/Packaging		Other		
Suspected Unapproved		Large Fab		Composite		Supplier				
Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____										
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Root Cause						FAULT CATEGORY				
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Design		Operator		Bending		Set-up		Folio/Program		Outside Dimensions
Doc/Data		Offset/Set up		Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance
Equip/Tooling		Supplier		Cracks		Broken/Damage/Defect		Weld		Part Incorrect
Handling/Pre		Training		Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified		Wrong Stock Pulled		Part Lost/Missing
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Past Expiry Date		Manufacturing Process		OTHER : _____ 						
Misidentified		Past Due								

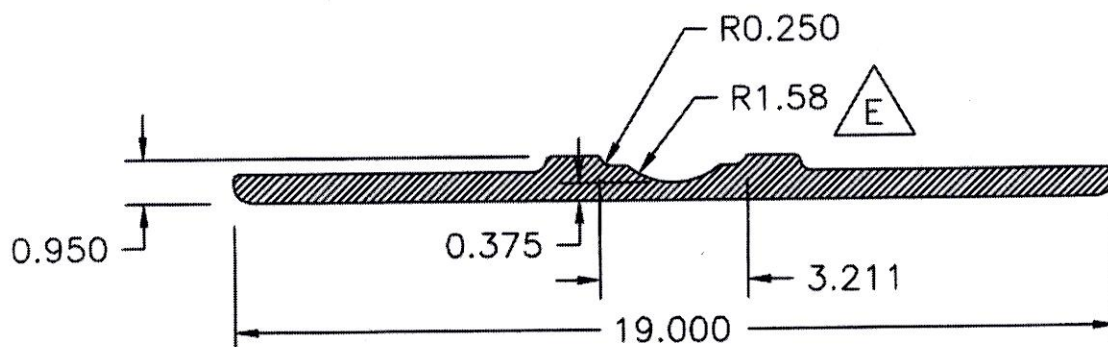


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DIB	APPROVED [Signature]	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19	TITLE BEARPAW		SCALE 1:4

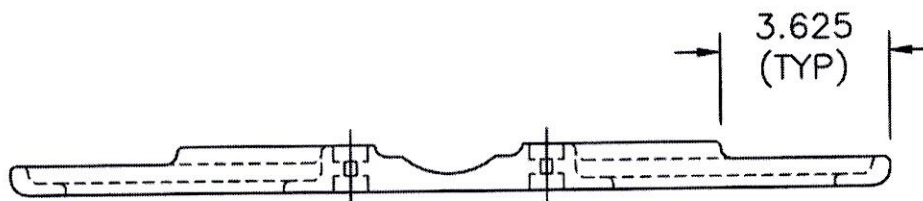
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

DQA: _____ Date: _____



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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

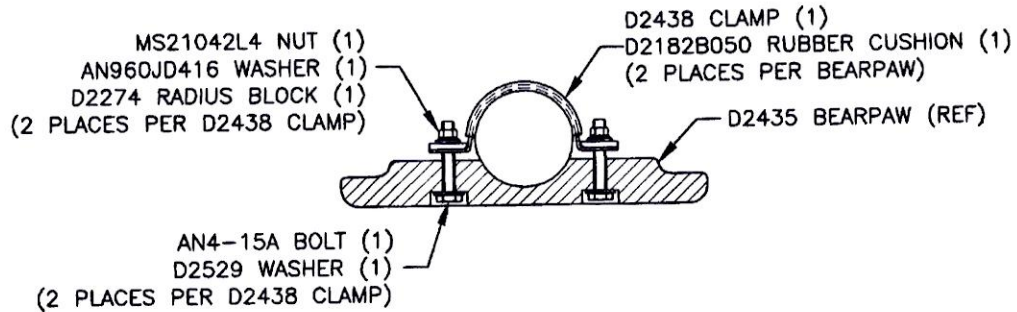


Figure 2 – Bearpaw Installation

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D120-638-011 Bearpaw	8.4 lb 3.82 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.7 in 4.54 m	1501.1 in-lb 17.34 m-kg

5. PARTS LIST

Qty	Part Number	Description
X	D120-638-011	BEARPAW INSTALLATION
4	D2182B050	Rubber Cushion
8	D2274	Radius Block
8	D2529	Washer
2	D2435	Bearpaw
4	D2438	Clamp
8	AN4-15A	Bolt
8	AN960JD416	Washers
8	MS21042L4	Nut (or MS21042-4)